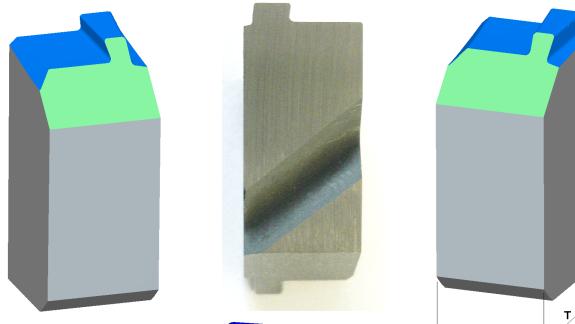


TopNotch Threading Insert

A08-100

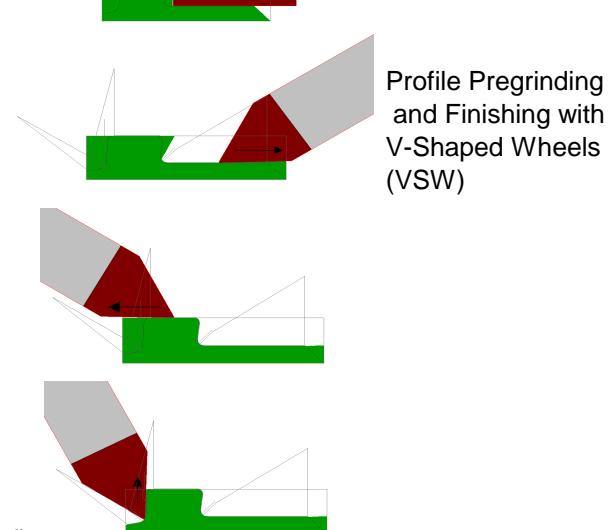
TopNotch Threading Inserts are very demanding and of highest precision. The below described VSW grinding process leads to optimal results and smooth connection of profile elements. A Probing routine after grinding keeps stability in the process and allows the production of large batches using the TopNotch clamping system and STL650 Robot Loader. If required, dressing cycles can be integrated.



1. Cycletime

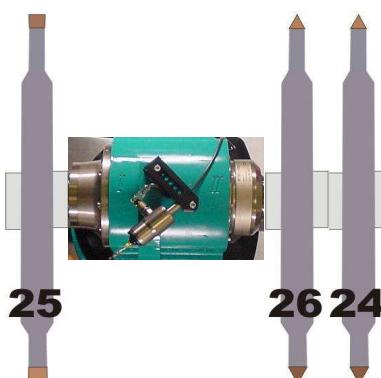
Tool specifications for doublesided Insert BxT 9.8 x 8.0 Material CARBIDE				
Operations	Prf Rough	Prf Pregr	Prf fin	Probe
Feed [mm/Min]	25	80	100	100
Power [kW]	2	1	1	1
Cutting feed [m/s]	22	22	22	
Used wheels	25	24	26	
Grinding time [s]	96	119	111	32
Total cycle time	5 Min 58			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.



2. Used Grinding Wheels

25 Ø300 1A1 D76
24 Ø300 14V1 D76
26 Ø300 14V1 D46



3. Machine and Software Requirements

Machine: 5 axes CNC grinder: SIR HPM, STL650, TopNotch automatic clamping
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.2, DXQ

responsible engineer: OP, 15.4.07

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